

Date: Monday, 22/09/2008 2:22:35 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|-----------------------|---|-----------------------|------------------|--------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : BOLT | | |
| Job Number | : 42201 | | Part Number | : D312121 | | |
| Estimate Number | : 10372 | | Drawing Number | : D3121 REV E | | |
| P.O. Number | : - | | Project Number | : N/A | | |
| This Issue | 22/09/2008 | S.O. No. : | Drawing Revision | : E | | |
| Prsht Rev. | : NC | | Material | : | | |
| First Issue | / / | Type : MACHINED PARTS | Due Date | : 29/09/2008 Qty: 250 Um: Each | | |
| Previous Run | : 40351 | | | | | |
| Written By | : | | | | | |
| Checked & Approved By | : <u>JUL 08-9-22</u> | | | | | |
| Comment | : Est. A04.02.09 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: |
|--|-----------------------|--|
| 1.0 | M303H0500 | 303 HEX BAR .500 |
| Comment: Qty: 0.0417 f(s)/Unit Total: 10.4250 f(s) 303 HEX BAR Material: AISI 303 SS 1/2" Hex Bar (M303H0.500) Batch: <u>M10 7980X28</u> <u>MANF 08/09/28</u> | | |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
| Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-21 2-Identify as D3121-21 3-Deburr break all sharp edges 0.005" to 0.010" <u>MANF 08/09/28</u> | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>MANF 08/09/28</u> | | |
| 4.0 | QC8 | SECOND CHECK |
| Comment: SECOND CHECK <u>Y.A</u> <u>08/10/08</u> | | |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>62</u> <u>8/10/08</u> <u>SP</u> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 2:22:35 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BOLT

Job Number: 42201

Part Number: D312121

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/09 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 28/10/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 42201 |
| Description: Bolt | Part Number: | D3121-21 |
| Inspection Dwg: D3121 | Rev: E | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

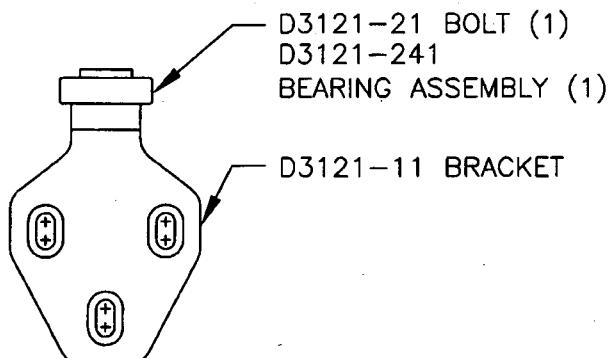
X First Article Prototype

| | | | | | |
|--------------|------------|-------------|------------|---------------------|-----|
| Measured by: | <i>M.W</i> | Audited by: | <i>J.A</i> | Prototype Approval: | N/A |
| Date: | 08/09/08 | Date: | 08/10/08 | Date: | N/A |

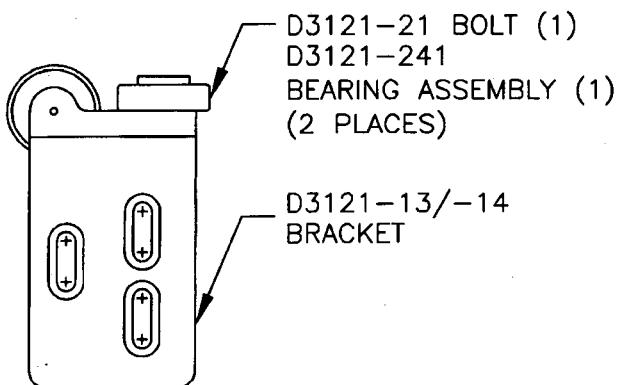
| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|------------|---|
| A | 04.02.27 | New Issue | KJ/RF | |
| B | 06.03.09 | Dwg Rev. updated | KJ/JLM | |
| C | 06.06.14 | Dwg Rev. updated | KJ/JLM | |
| D | 08.01.16 | Dwg Rev. updated | KJ/EC/DD | |
| E | 08.07.23 | Dimensions updated | KJ/DD |   |

DART

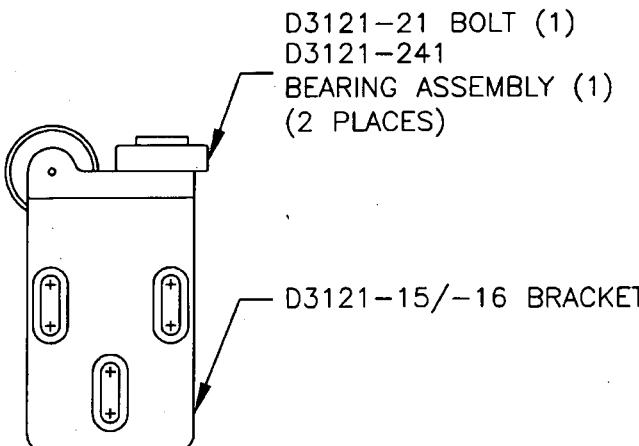
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|---------------------|-----------------------|---|-------------------------|
| DESIGN <i>4</i> | DRAWN BY <i>CE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>4</i> | APPROVED <i>4</i> | DRAWING NO. D3121 | REV. E SHEET 1 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |
| A | 02.04.15 | NEW ISSUE | |
| B | 03.01.16 | ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146 | |
| C | 04.02.17 | ADD CLEARANCE; USE -241 BEARING | |
| D | 06.05.17 | D3121-25 CAP WAS 1.024, NOW 1.000 | |
| E | 07.11.07 | ADD TOLERANCE TO 0.032 (DETAIL B) | |

RELEASED
07.11.07**D3121-041 BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-33)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-37/-38)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-35/-36)

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WORK ORDER

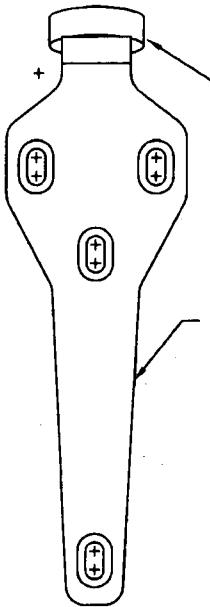
NO. *42201*

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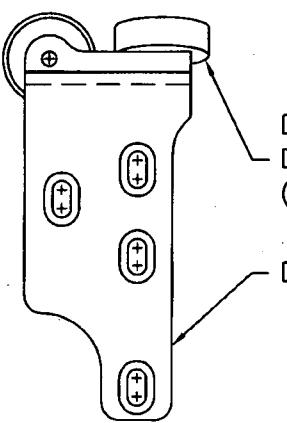
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| DESIGN <i>4</i> | DRAWN BY <i>CE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>4</i> | APPROVED <i>W</i> | DRAWING NO. D3121 | REV. E SHEET 2 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

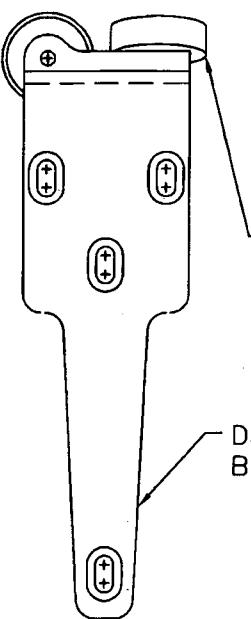
RELEASED
07.11.07 W



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

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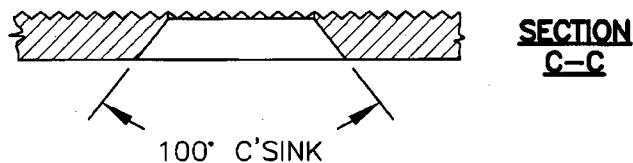
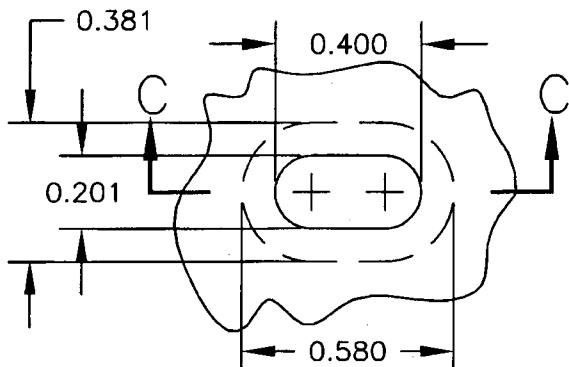
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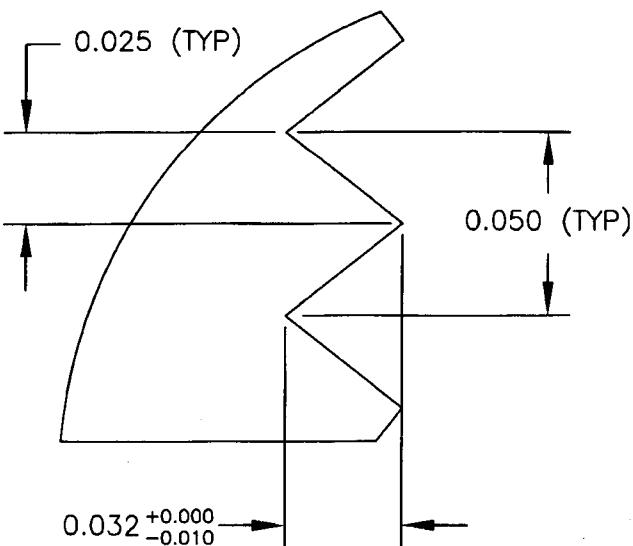
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|----------------------|-----------------------|---|-------------------------|
| DESIGN <i>CH</i> | DRAWN BY <i>CE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CH</i> | APPROVED <i>-#</i> | DRAWING NO. D3121 | REV. E SHEET 3 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



RELEASED
07.11.07 *W*

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



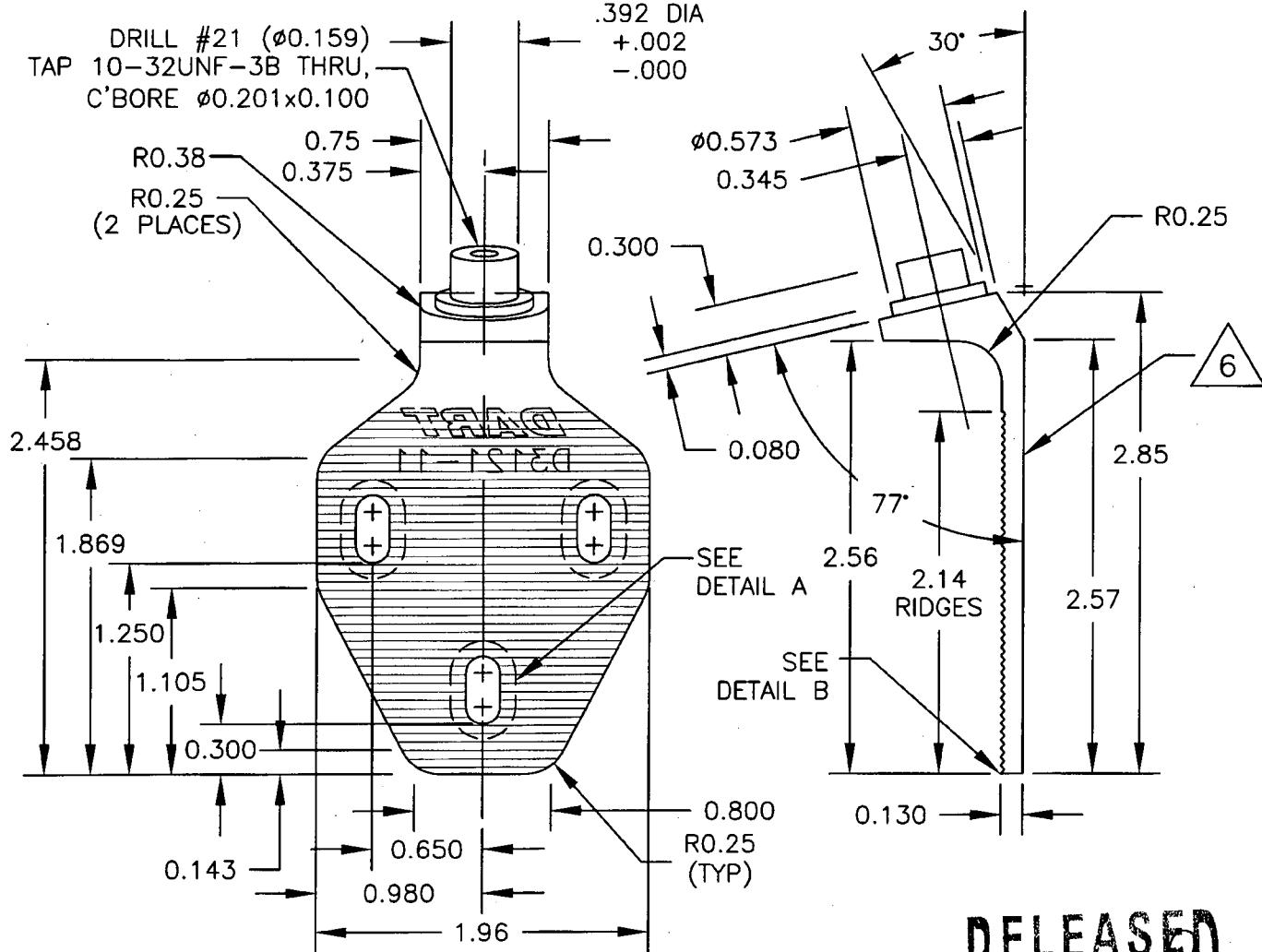
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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| DATE | 07.11.07 | TITLE | SHEET 4 OF 10 1:1 BRACKET ASSEMBLY |

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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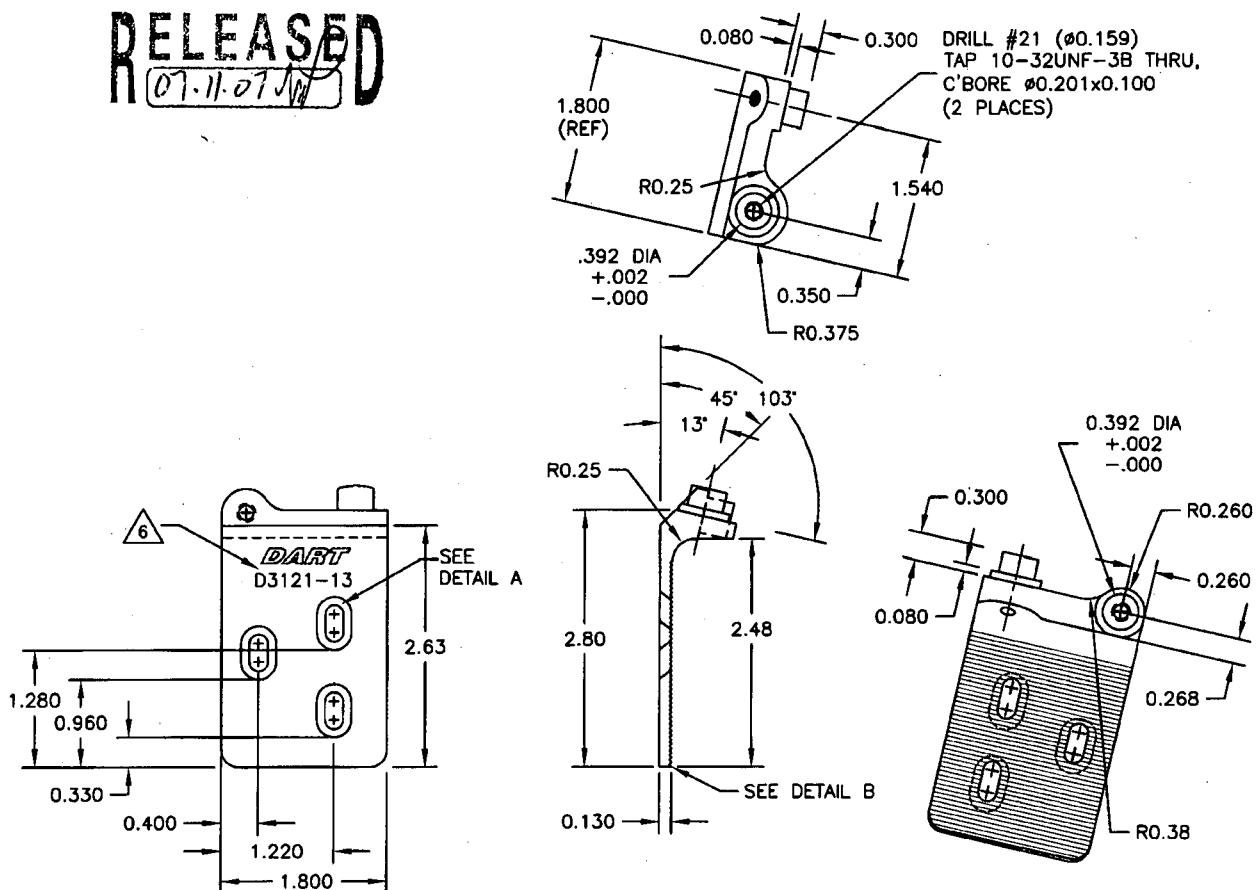
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| CHECKED  | APPROVED  | DRAWING NO. D3121 | REV. E | SHEET 5 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 | |

RELEASER
07.11.07



D3121-13 BRACKET (SHOWN)

D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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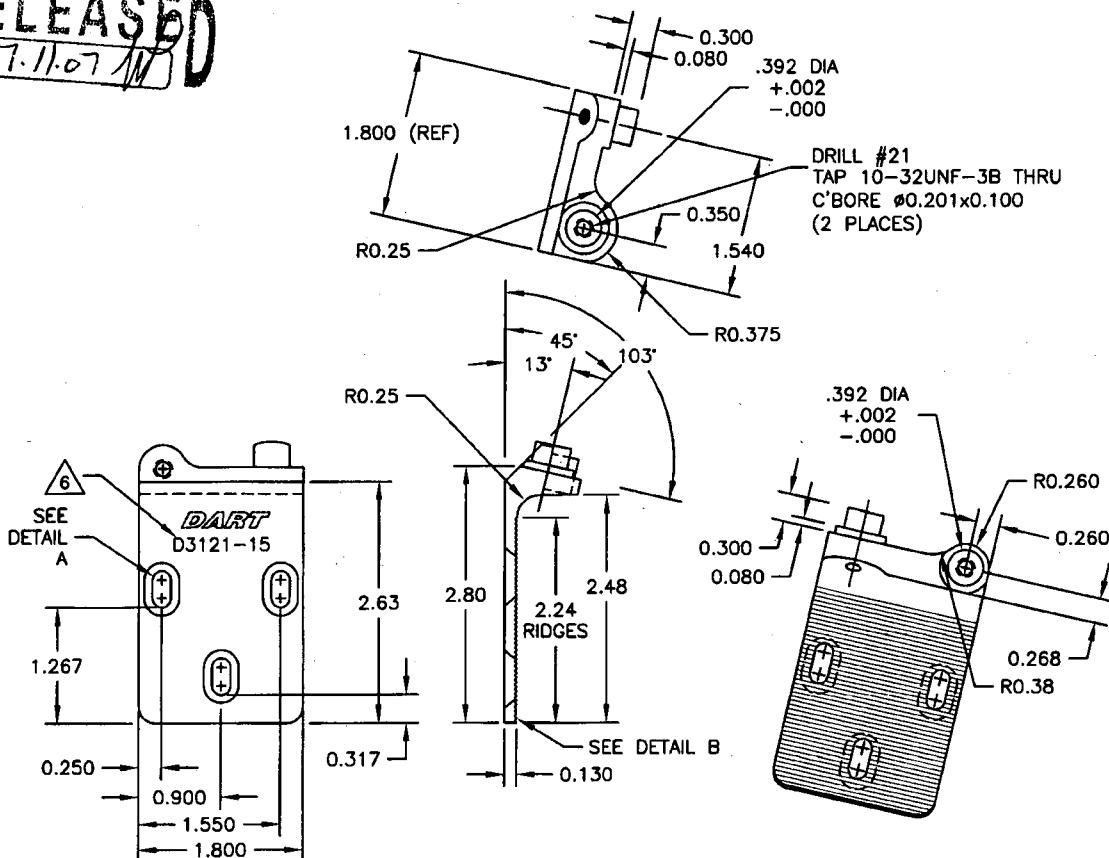
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WORK ORDER

NO. 4-220

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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| | | D3121 | SHEET 6 OF 10 |

DATE
07.11.07TITLE
BRACKET ASSEMBLYSCALE
1:2**RELEASED**
07.11.07

D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| CHECKED <i>4</i> | APPROVED <i>4</i> | DRAWING NO. D3121 | REV. E SHEET 7 OF 10 |
| DATE 07.11.07 | TITLE BRACKET ASSEMBLY | | SCALE 1:2 |

RELEASED
07.11.07 / W

RELEASER
07.11.07/W

DRILL #21 ($\phi 0.159$)
TAP 10-32 UNF-3B THRU
C'BORE $\phi 0.201 \times 0.100$

0.392 O.D.
+.002
-.000

0.75
0.375

R0.375
R0.25
(2 PLACES)

0.300
0.345
0.080

30°

0.573 O.D.
R0.25

2.14 RIDGES

77°

SEE DETAIL B

5.788

5.160

4.580

4.530

3.630

3.330

3.473

0.950

0.280

0.600

0.664

0.98

1.96

5.89

6.18

6.22

5.90

0.130

SEE DETAIL A

D3121-111 BRACKET

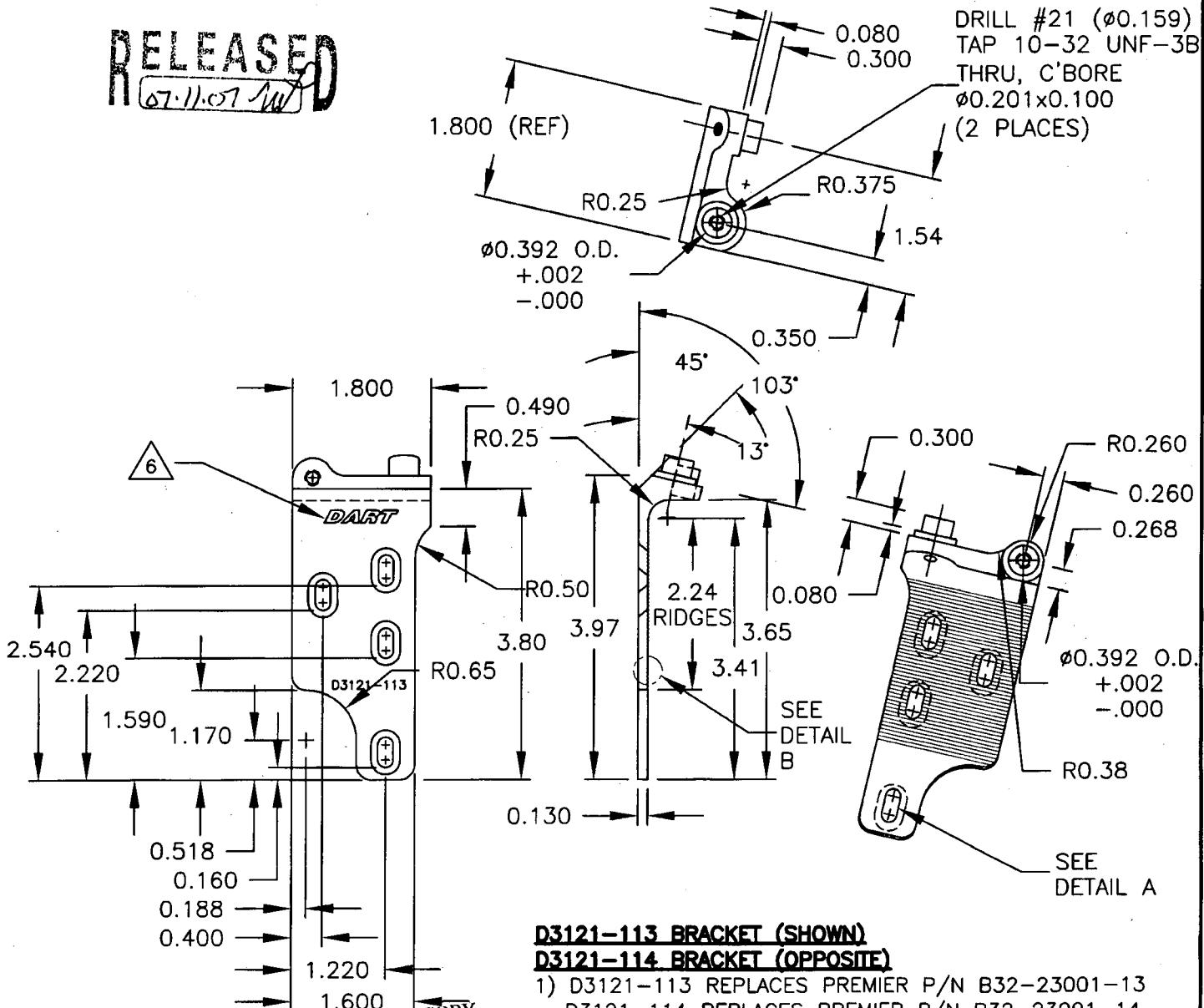
- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| | | D3121 | SHEET 8 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |

RELEASED
07.11.07 *W*



**D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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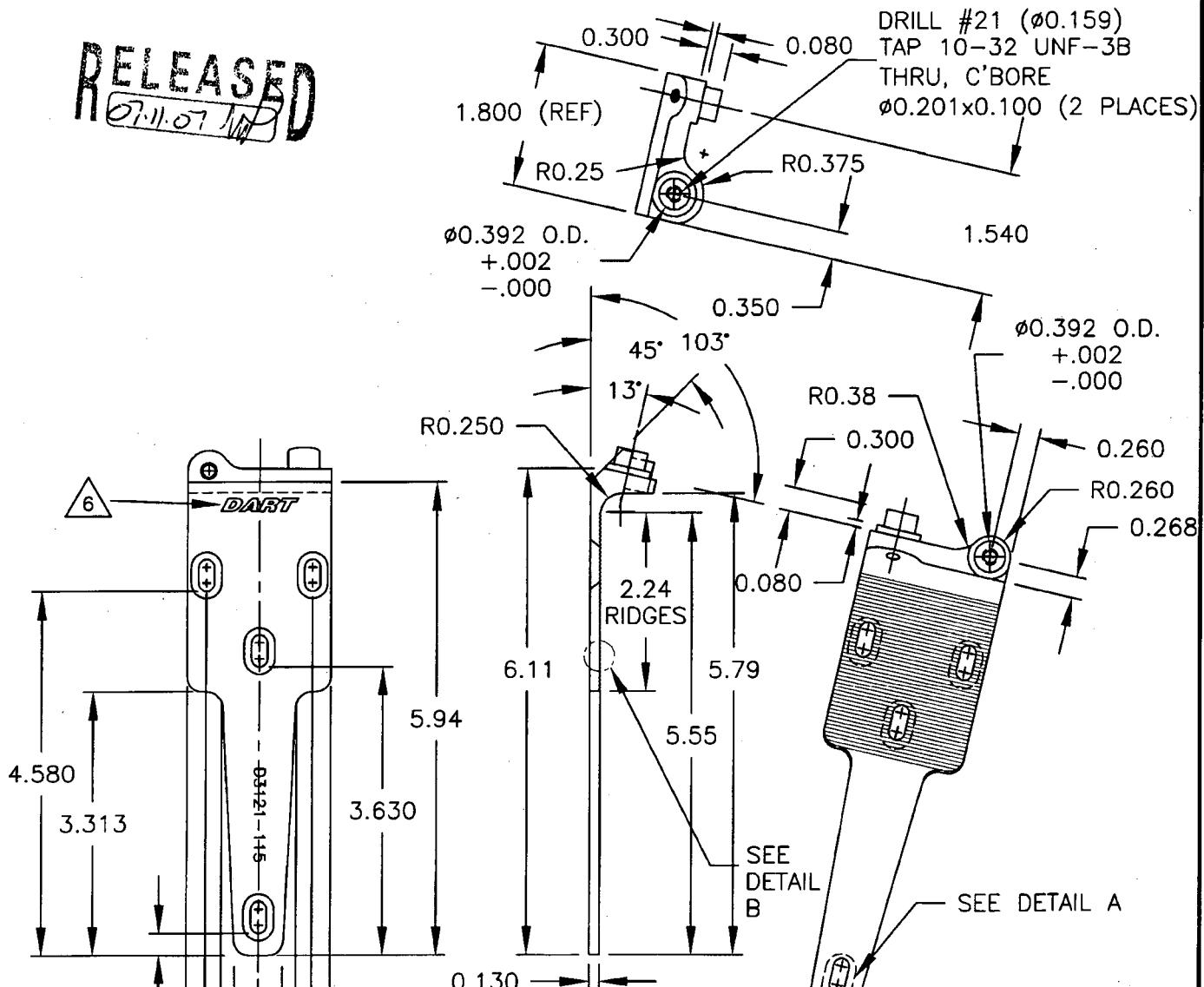
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| CHECKED | APPROVED | DRAWING NO. | REV. E |
| | | D3121 | SHEET 9 OF 10 |
| DATE | | TITLE | SCALE |
| 07.11.07 | | BRACKET ASSEMBLY | 1:2 |

RELEASED
07.11.07

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi

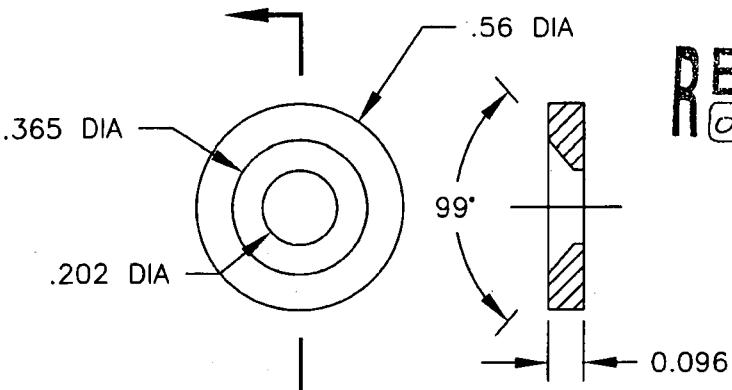
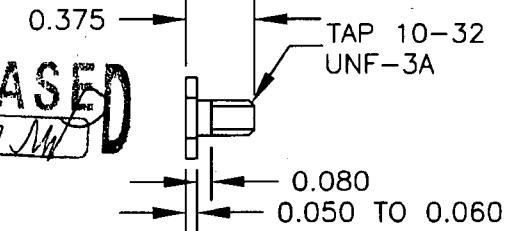
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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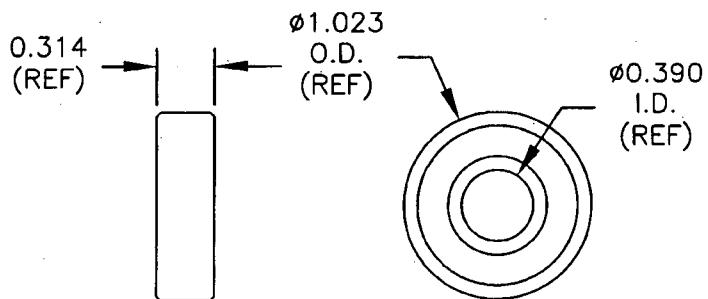
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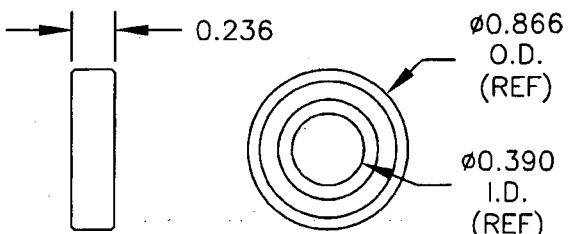
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|----------------------|-----------------------|---|--------------------------|
| DESIGN <i>CH</i> | DRAWN BY <i>CE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CH</i> | APPROVED <i>CH</i> | DRAWING NO. D3121 | REV. E SHEET 10 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |

**RELEASED**
07.11.07 *MW***D3121-17 WASHER (SCALE 2:1)**

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

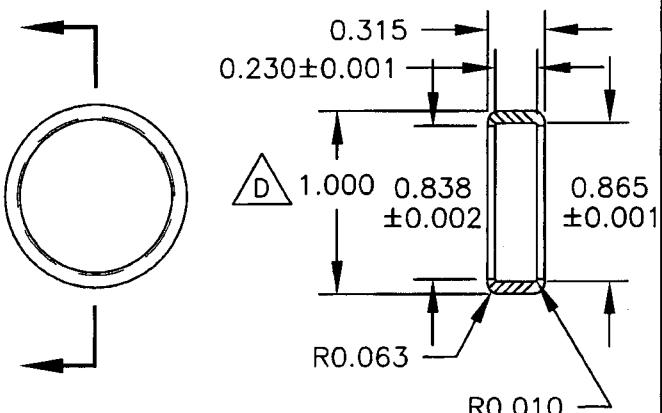
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

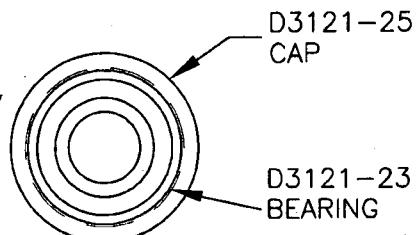
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**